

Date: Wednesday, 1/31/2007 2:18:24 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	MOUNTING LUG
Job Number	30545		
Estimate Number	10256		
P.O. Number	N/A	Part Number	D22303
This Issue	1/31/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D2230 REV F
First Issue	N/A	Project Number	N/A
Previous Run	30273	Drawing Revision	F
Written By		Material	N/A
Checked & Approved By	<u>CH</u> 07.01.31	Due Date	2/7/2007
Comment	Qty: 196 Um: Each Est D 00:55:18 Added inspection level 8, and removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2423	Lug Extrusion
		Comment: Qty.: 0 f(s)/Unit Total : 14 f(s) Lug Extrusion D2423 Batch: 30062
2.0	BAND SAW	BAND SAW
		Comment: Band Saw Cut D2423 extrusion to 0.82" Batch: 30062
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2230-3 Check for crack while loading into the machine. Issue P.O. 3264 Machine per draw D2230 Rev F C/S 07/03/08 196 30062
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE Receive + inspect for transit damage PC 2/3/15 196
5.0	QC5	SECOND CHECK Comment: SECOND CHECK Inspect levels 5 P 0703-21 196 ES 019

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/03/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:18:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 30545

Part Number: D22303

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: 8 SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

MIA 2

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MIA /M-1 07-03-21

8.0 QC3 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

u 07-03-21

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

MIA 07/03/21

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/INSPECT POWDER COAT

07/03/21 (196)

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/03/26

196
07/03/25 SD

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/27

Job Completion



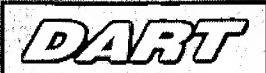
07/03/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

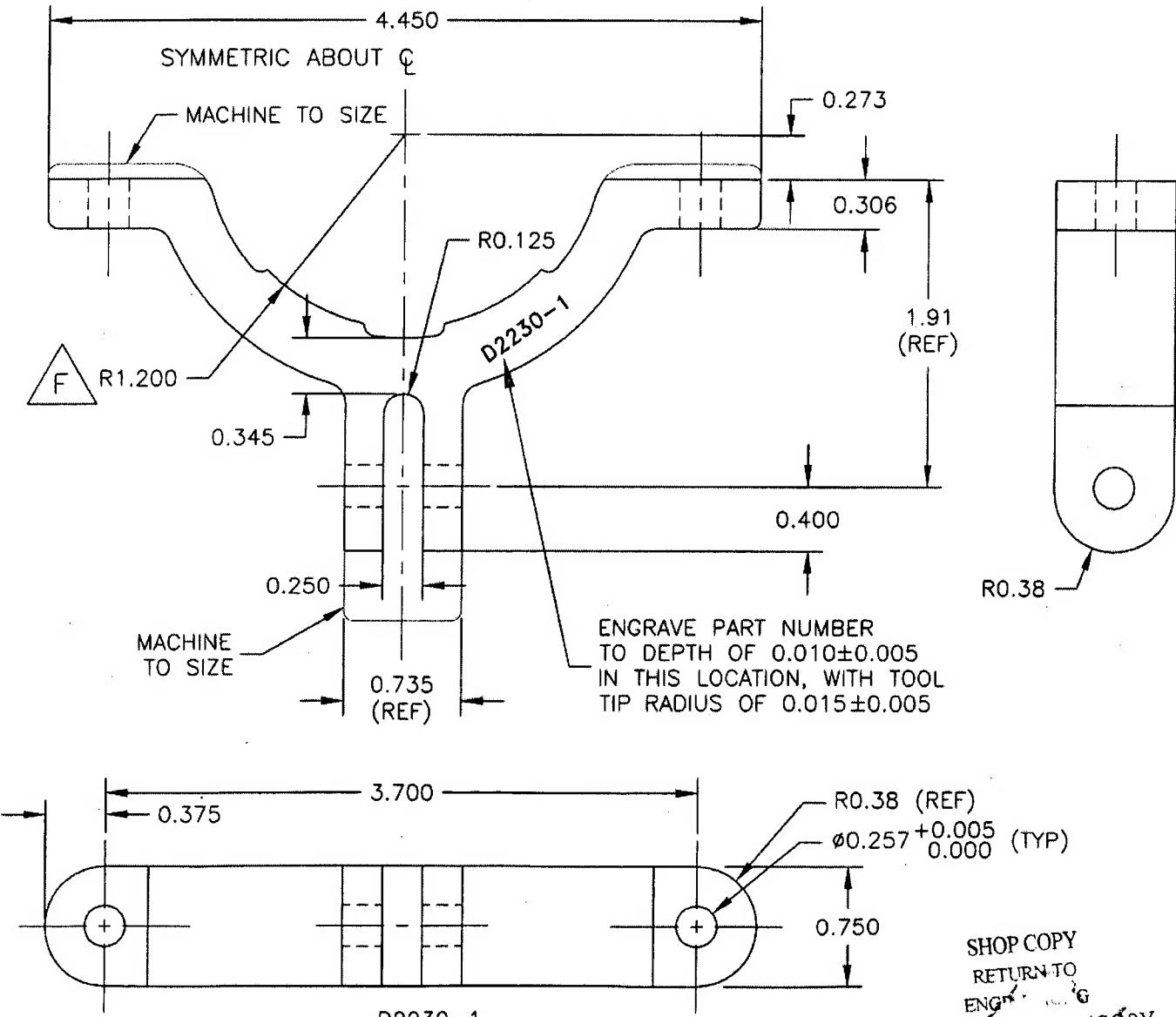
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230
DATE		REV. F SHEET 1 OF 2
99.12.13		TITLE MOUNTING LUG
C	94.03.30	SCALE 1:1
D	95.01.04	
E	95.01.04	
F	99.12.13	REDESIGN; R1.200 WAS R1.100

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015

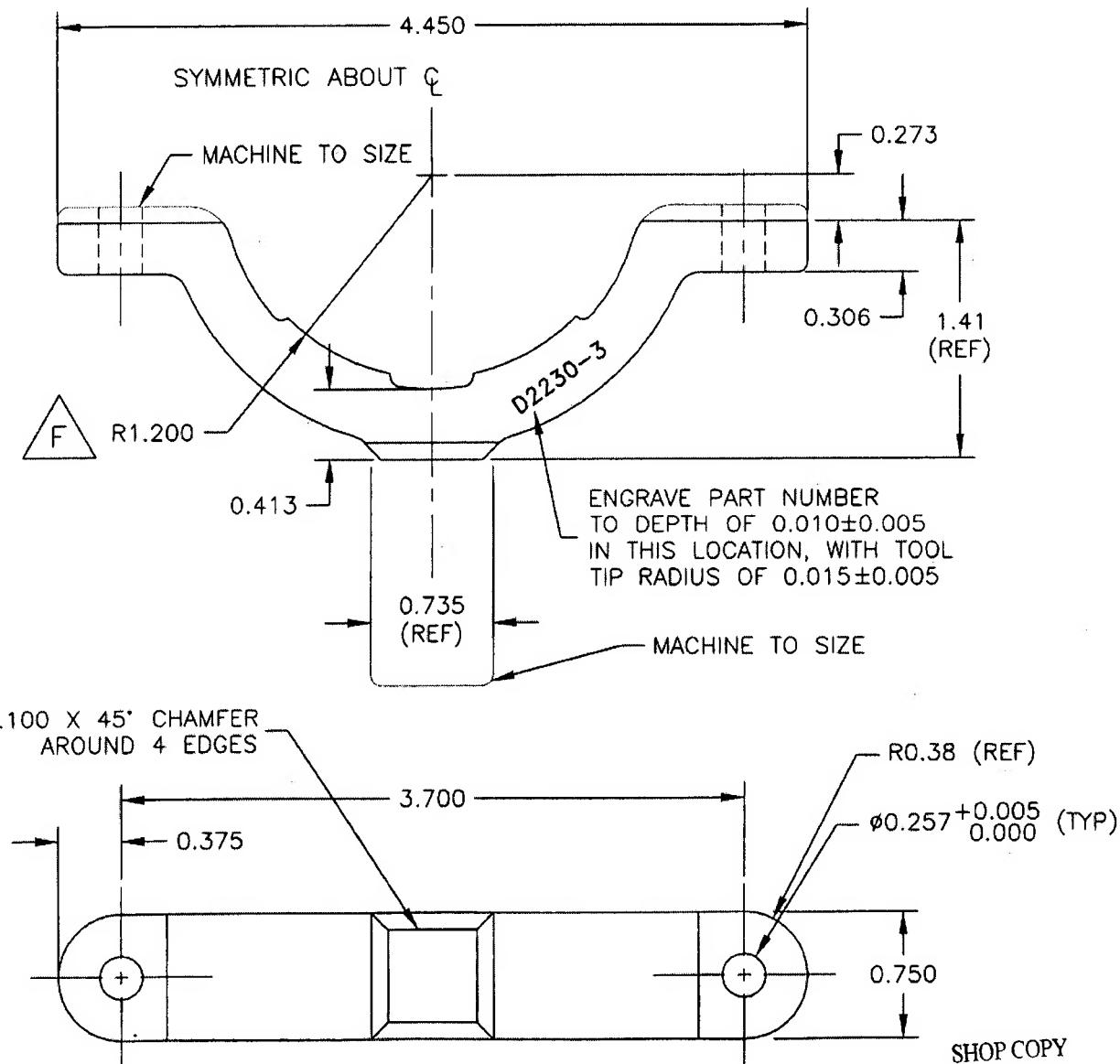
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 NO. 30545

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	X	APPROVED	X	DRAWING NO. D2230 REV. F SHEET 2 OF 2
DATE	99.12.13	TITLE	MOUNTING LUG	SCALE 1:1

RELEASED
99.12.21 DSMAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SOLICIT AMENDMENT
NOTICE
NO. 30545



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956



Delivery Slip No.: 15799
Date: Mar 19, 2007
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 3264 <i>PRO</i>	Sold By: Walz, Christian D.
Shipped By: our truck	Ship Date: Mar 19, 2007

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-3 Mounting Lug B30545 Material supplied by DART #2423 B30062	Each		196	

Received by Sonia Annis

Thank you for your order!



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

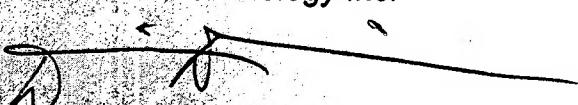
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
196	D2230-3	Mounting Lug B30545	3264

MATERIAL: supplied by DART D2323 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Denise Robinson

Vankleek Hill, March 19, 2007